

Work Order ID 92958 -2 Split -2
November-12-12 1:37:22 PM

92958

Page 1

Item ID: D4635-4

Revision ID:

Item Name: Aft Ceiling Panel, RH

Start Date: 12/11/2012 Start Qty: 2.00

Required Date: 12/12/2012 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: 12-11-12 Tooling:

QC:

Date:

SPC (Y/N):

Date:

Date:

Run Start

NR1

Stop

NR2

Sequence ID/

Operation
Description

Set Up/
Run

Tool #

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Rejec
Number

insp.
Stamp

D4635

Reo B 12/12/12

100

100

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Cut Blanks

0.00

0.00

x2

105

105

HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 KYDEX

0.00

0.00

x2

Temp: 150°F

Time IN: 2:00 pm 12/12/03

Time OUT: 7:00 am 12/12/04

D4635
12/12/04

12/12/04

Work Order ID 92958

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Page 2

Item ID: D4635-4

Revision ID:

Item Name: Alt Ceiling Panel, RH

Start Date: 12/11/2012 Start Qty: 2.00

Required Date: 12/12/2012 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

110

110

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

0.00

Memo

0.00

Thermoform as per Dwg. D4635-4 and Folio FTA150

Dwg. Rev. A

Folio Rev. A

Visually inspect for proper formation and texture

x2

Ph

12/12/04

130

130

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Trim to Finished Dimensions

X1

BB

13/03/20

140

140

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

X1

BB

13/03/20

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Page 3

Item ID: D4635-4

Revision ID:

Item Name: Aft Ceiling Panel, RH

Start Date: 12/11/2012 Start Qty: 2.00

Required Date: 12/12/2012 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

150

QC

Quality Control

QCS- Inspect part completeness to step on W/C

0.00

16 13/03/21

Memo

location

160

160

Packaging

Packaging

Packaging

Memo

0.00

0.00

MED TAB

13/03/25

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

13/3/27

MF 13-3-26

Picklist Print

November-12-12 1:37:26 PM

Page 1
T

Work Order ID: 92958

Parent Item: D4635-4

Parent Item Name: Att Ceiling Panel, RII

92958

D4635-4

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,028.362	8.49	18.86667			

MKYD6185S 080-P3-62015

6185 KYDEX .080"

**

Wh

12/12/12

Location

therm

Loc Qty

1028.362377

Loc Code

116576

14.148377

121756

1014.214

18.87 sf

DART AEROSPACE LTD		Work Order: Q2958.
Description: 139 AFICELING BH		Part Number: D4635-4
Inspection Dwg: 4635 Rev: B.		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: B/03/19

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40.10	.030	40.06	✓			TH-05
15.46	.030	15.49	✓			TH-05
1.30	.030	1.30 1.30	✓			TH-09
3.80	.030	3.82	✓			TH-09
17.00	.030	17.00	✓			TH-05
34.00	.030	34.00	✓			TH-05
7.00	.030	7.02	✓			TH-05
20.56	.100	20.56	✓			TH-05
26.5	.100	26.55	✓			TH-05
2.03	.030	2.031	✓			TH-05
3.50	.030	3.508	✓			

Measured by: JB

Audited by: 16 13/03/20

Preliminary Approval:

Date: 13/03/20

Date:

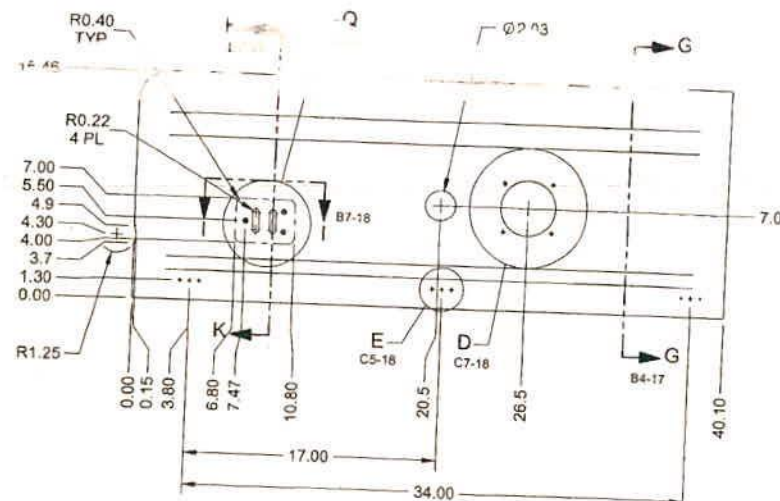
Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



SECTION J-J C2-16



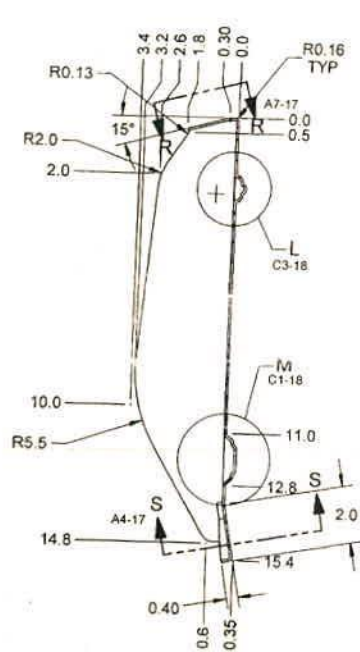
D4635-4 RH, AFT CEILING PANEL

NOTES:

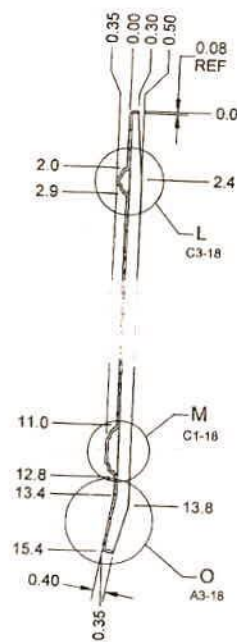
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.60 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-4 PER TOOL DT9842
- 10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

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2013-01-30

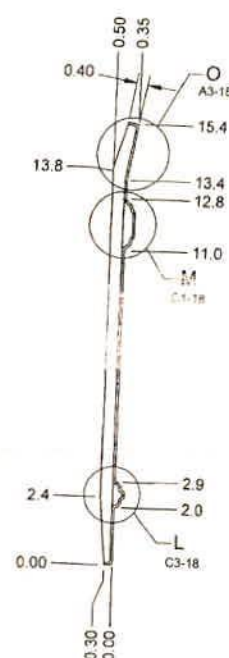
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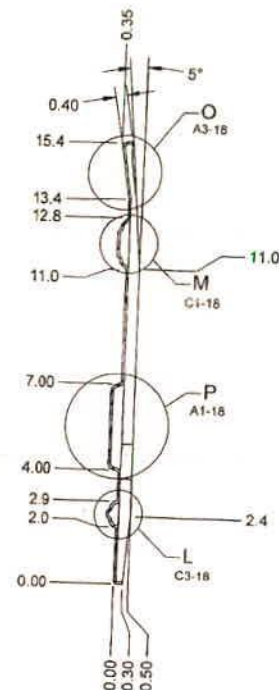
SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X



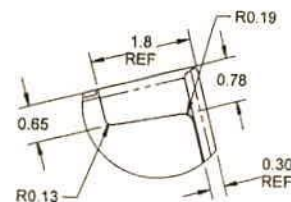
SECTION B-B
SCALE 2X



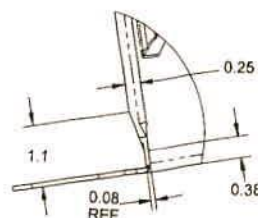
SECTION G-G
SCALE 2X



SECTION K-K
SCALE 2X



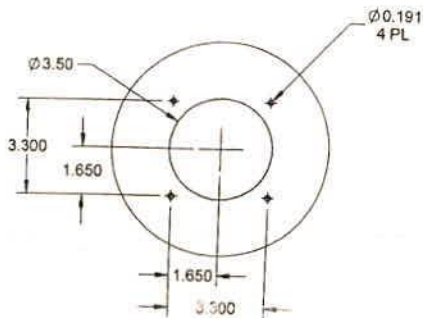
AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X



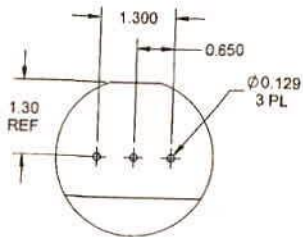
AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

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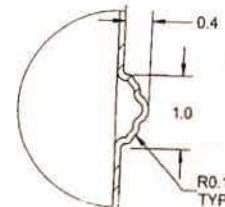
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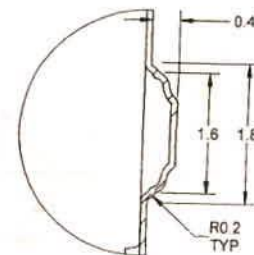
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B4-13
B3-14
B5-15
B5-16



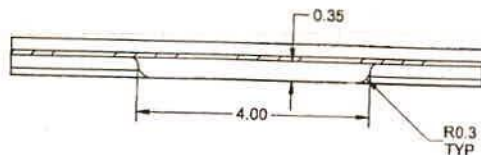
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C7-13
B6-14
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B5-16



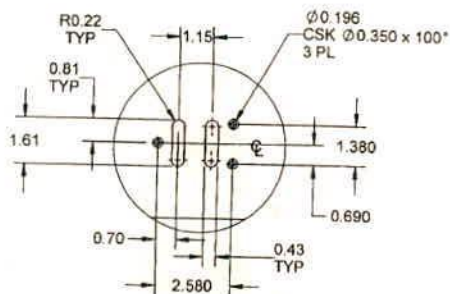
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C7-17



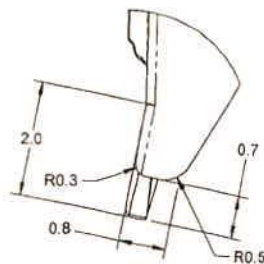
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C3-17
C5-17
C7-17



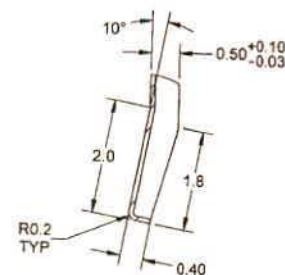
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SCALE 4X
B5-16



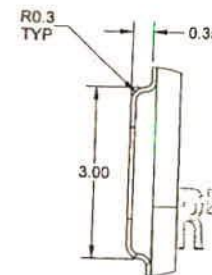
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SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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